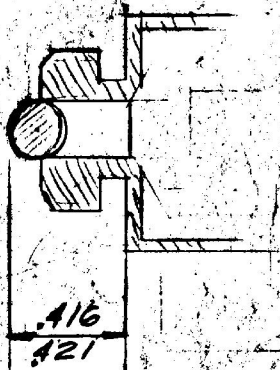


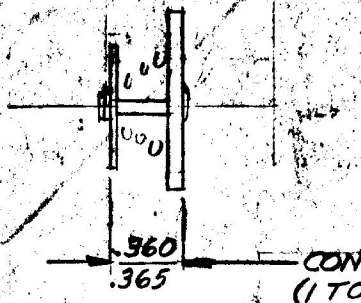
①

HOUSING AND BALL SUB-ASSY



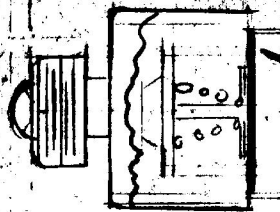
TOOL # B-25-11
GAGE # 9088A-1

②



CONTROLLED AT
(1 TON) HYDR.
TOOL # R-23-5

③



SIZE WITH GASKET IN
PLACE ON 1 TON HYDR.
2000 LBS. PRESSURE

TOOL # 5-24-4

— NOTES —

① SIZING OPERATION - (SKETCH 3) IS CONTROLLING INFLUENCE TO INSURE ACCURATE CONTACT POSITION AND WASHES OUT MFG. TOLERANCES OF MOST COMPONENTS.

③ AT EACH PRODUCTION RUN PILOT LOTS SHOULD BE SIZED, FINAL CLOSED AND TESTED TO ASSURE COMPLIANCE WITH CONTACT TOLERANCE ADJUSTMENTS TO HYDRAULIC PRESSURE AND SIZING TOOL MAY BE AT TIMES ADVISABLE.

④ FINAL CLOSING TOOL SHOULD BE SET AT 2000LBS AND SHOULD RESULT IN APPROX. 80% GOOD AND 20% "NO LITE" - THOSE IN CATEGORY OF "NO LITE" CAN THEN BE RESTRUCK AT 3500LBS.

⑤ CHECK ALL PARTS AND SUB-ASSEMBLIES TO DWGS. AVAILABLE BEFORE ASSY OPERATIONS, SEE DWG NO'S LISTED ON THIS SHEET.

— OPERATIONS —

9242

1- ASSEMBLE 9088-2 BALL TO 9088A-1 HOUSING + SIZE AND TRAY
TOOL # B-25-11 SEE SKETCH #1 GAGE # A16-A21

DWG # 9088A-101

2- ASSEMBLE 9146-103 CONTACT ASSY. # 9146-9 EYELET, 9146-8 CONTACT AND TRAY HYDR. (1 TON) - SEE SKETCH #2
TOOL #

9133-101
9146-103
9242-101

3- ASSEMBLE # 97050 - OIL SEAL TO # 9088A-3 SHAFT # O-N-J PRESS
TOOL # B-25-11

9242-102
9088A-1
9088-2

4- ASSEMBLE 9088A-101 OIL SEAL & SHAFT ASSY # 9088A-25 CUP # 88526 WASHER INSULATOR AND CONTACT ASSY AND 9162-16 GASKET AND TRAY.

88526
9088A-25
9162-16
9088A-3
97050
9088-19

5- SIZE ABOVE ASSY HYDR. (6 TONS)
TOOL # 5-24-4 AND TRAY

9146-B
9146-9
88525
9088-20

6- ASSEMBLE # 9088A-26 SPRING # 9133-101 TERM. INSULATOR ASSY TO ABOVE ASSY AND CLOSE
HYDR. (6 TONS) TOOL # K-28-14

9146-10
88525

7- CIRCUIT TEST
FIXTURE #

LET	WAS	DATE	BY	LET	WAS	DATE	BY	MATERIAL	DRAWN	CHECKED	APPR'D	SCALE	USED ON	DATE DRAWN
										✓				2-4-60
								FINISH	COLE-HERSEE COMPANY BOSTON 27, MASS., U.S.A.				DATE ISSUED	
								TOLEANCES FRACTIONAL ± DECIMAL ±	NAME	ASSEMBLY PROCEDURES				PART NO. 9242